

Work Order ID 163178

Thursday, June 22, 2017 1:50:46 PM

163178

Page 1

Item ID: D119-796-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED SHIP 7/21

Approvals:

Process Plan:

Date: JUN 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-021	A
IIN-D119-796	F

100

Pick Kit

0.00

100

Packaging

Memo

0.02

Packaging

Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork

DAS
6
9-03

JUL 06 2017

110

Assemble as per dwg

0.00

110

HandFinish

Memo

1.37

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH:

2-INSTALL DECAL D2729-4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 163178

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Page 2

Item ID: D119-796-021**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** AW119 Standard Landing Gear Assembly - Standard OEM Protection**Start Date:** 7/10/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/14/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:** SCHEDULED SHIP 7/21**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.50				_____	_____	_____	_____
123 *123* Packaging Packaging	Pick Kit Memo	0.00 0.00				_____	_____	_____	_____
126 *126* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				_____	_____	_____	_____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D119-796-021**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** AW119 Standard Landing Gear Assembly - Standard OEM Protection**Start Date:** 7/10/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/14/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:** SCHEDULED SHIP 7/21**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.25							
Packaging	Identify and pack for shipping as per PPP D119-796-021 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									



SEP 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

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Page 1

Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-646-041		Manufactured	No			100	Each	0.0000	2	2			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D119-646-041

AW119 Replacement Skidtube with Wearpads - Fits LH or RH

D119-796-151		Manufactured	No			100	Each	0.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D119-796-151

FWD Crosstube Installation with Step (no hardware)

D119-796-251		Manufactured	No			100	Each	0.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D119-796-251

AFT Crosstube Installation with Step (no hardware)

D2652		Manufactured	No			100	Each	342.0000	48	48			
-------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--

D2652

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

FG	44	
----	----	--

31985	44	
-------	----	--

ST009	298	
-------	-----	--

161518	298	
--------	-----	--

D3407-041		Manufactured	No			100	Each	11.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3407-041

Tow Ring

Location	Loc Qty	Loc Code
----------	---------	----------

st530	11	
-------	----	--

159443	11	
--------	----	--

DAS
6
9-89

JUL 06 2017

DAS
6
9-89

JUL 06 2017

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

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Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

D3417-5

Manufactured No

100

Each

63.0000

4

4

D3417-5

Washer

**

DAS

6

9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST034

2

156835

2

ST038A

61

158791

61

D3456-1

Manufactured No

100

Each

121.0000

2

2

D3456-1

Washer

**

DAS

6

9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG

6

25701

6

ST036

115

159500

19

162291

96

D3672-3

Manufactured No

100

Each

364.0000

48

48

D3672-3

Washer, Phenolic

**

DAS

6

9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

133

132639

133

ST047

131

153930

131

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

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Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

100

Each

615.0000

48

48

D3672-7

Washer, Phenolic

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG

41

129987

6

133986

15

153039

20

ST047

74

153039

74

ST051A

500

157442

500

48

D3883-1

Manufactured No

100

Each

9.0000

2

2

D3883-1

Saddle, Outboard LH

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST404

9

153815

1

161650

8

2

D3883-2

Manufactured No

100

Each

6.0000

2

2

D3883-2

Saddle, Outside RH

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST404

6

157414

6

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

D3884-1

Manufactured No

100 Each

9.0000

2 2

D3884-1

Saddle, Inside LH

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST404

9

157342

1

161651

8

D3884-2

Manufactured No

100 Each

4.0000

2 2

D3884-2

Saddle, Inside RH

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST404

4

161652

4

D3886-041

Manufactured No

100 Each

15.0000

4 4

D3886-041

Lug Assembly

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST228

1

151001

1

ST528

8

157602

8

ST532A

6

156995

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Thursday, June 22, 2017 1:50:45 PM

Work Order ID: 163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Bolt

AN3C46A

Purchased

No

100

Each

28.0000

8

8

JUL 06 2017

DAS 9-89

Location

FG

122843

ST346

m136055

m136181

10

8

18

10

10

Loc Qty

Loc Code

**

JUL 06 2017

DAS 9-89

AN3C50A Bolt

AN3C50A

Purchased

No

100

Each

246.0000

16

16

JUL 06 2017

DAS 9-89

Location

OVER002

M137074

ST346

M136503

94

94

152

152

Loc Qty

Loc Code

**

JUL 06 2017

DAS 9-89

AN4C6A Bolt

AN4C6A

Purchased

No

100

Each

148.0000

24

24

JUL 06 2017

DAS 9-89

Location

FG

103344

121657

ST345

m136318

m137026

84

50

134

10

4

14

Loc Qty

Loc Code

**

JUL 06 2017

DAS 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

Thursday, June 22, 2017 1:50:45 PM

Page 6

Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

100

Each

636.0000

24

24

MS21043-3

Nut

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	119	
m136182	119	
GA	88	
m136182	88	
OVER007	300	
m137587	300	
ST302	49	
m137459	49	

24

MS21043-4

Purchased

No

100

Each

750.0000

26

26

MS21043-4

Nut

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	99	
m132803	5	
m137371	94	
OVER007	300	
m137886	300	
ST302	311	
m137361	111	
m137371	200	

26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Thursday, June 22, 2017 1:50:45 PM

Page 7

Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

100

Each

129.0000

8

8

MS21043-5

Nut

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

71

116548

71

ST302

38

m137361

38

MS21250-05048

Purchased

No

100

Each

62.0000

8

8

MS21250-05048

Bolt (use MS21250-05-048)

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

ST295

62

m135948

62

NAS1149C0332R

Purchased

No

100

Each

4,910.000

24

24

NAS1149C0332R

WASHER

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

932

m137381

932

24

Thursday, June 22, 2017 1:50:45 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, June 22, 2017 1:50:45 PM

Page 8

Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

1,235.000

48

48

NAS1149C0432R

WASHER

**

JUL 06 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

341

m134676

341

ST266

894

m137459

894

NAS1149C0532R

Purchased

No

100

Each

353.0000

16

16

NAS1149C0532R

WASHER

**

JUL 06 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

84

m135390

8

m136983

76

GA

42

116513

42

ST266

227

m136192

27

m137886

200

139x89x35crate

Purchased

No

100

Each

0.0000

1

1

139x89x35crate

Agusta Crate

**

JUL 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 163178

163178

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21920-28

Purchased

No

123

Each

91.0000

2

2

MS21920-28

Clamp

**

DAS
6
9-89

JUL 06 2017

Location

Loc Qty

Loc Code

FG	1	
105884	1	
LG050	78	
M136579	3	
M137075	25	
M137361	25	
M137508	25	
LG051	1	
M132169	1	
LG057	2	
M134130	2	
st543	9	
M136740	9	

2

DQA: _____ Date: _____



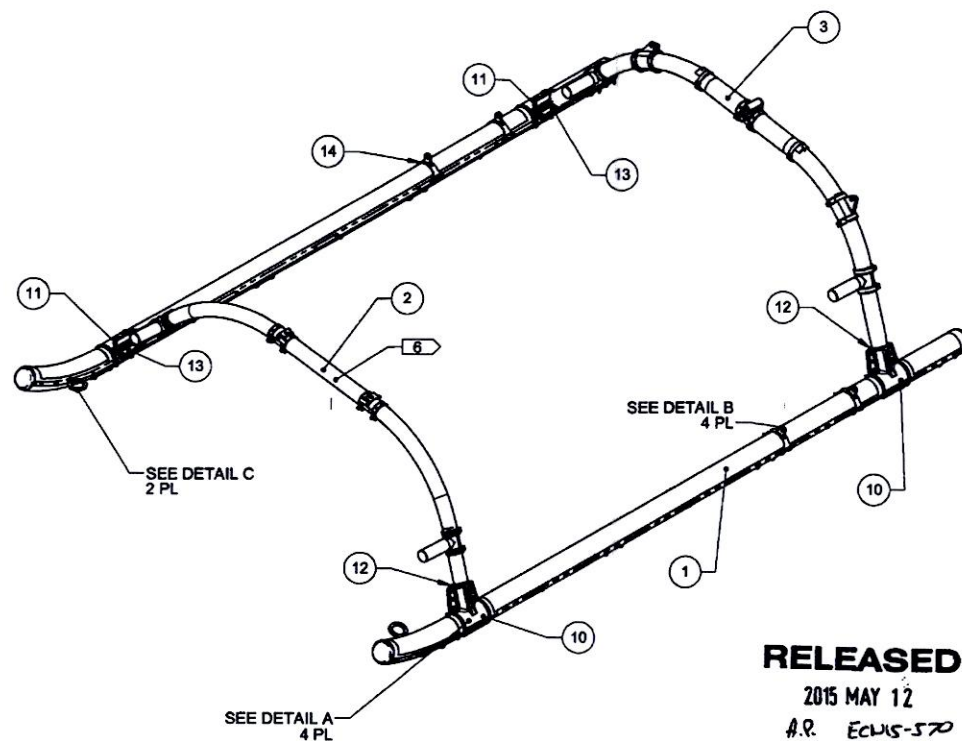
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. 438		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : 438		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 1631781
JUN 22 2011

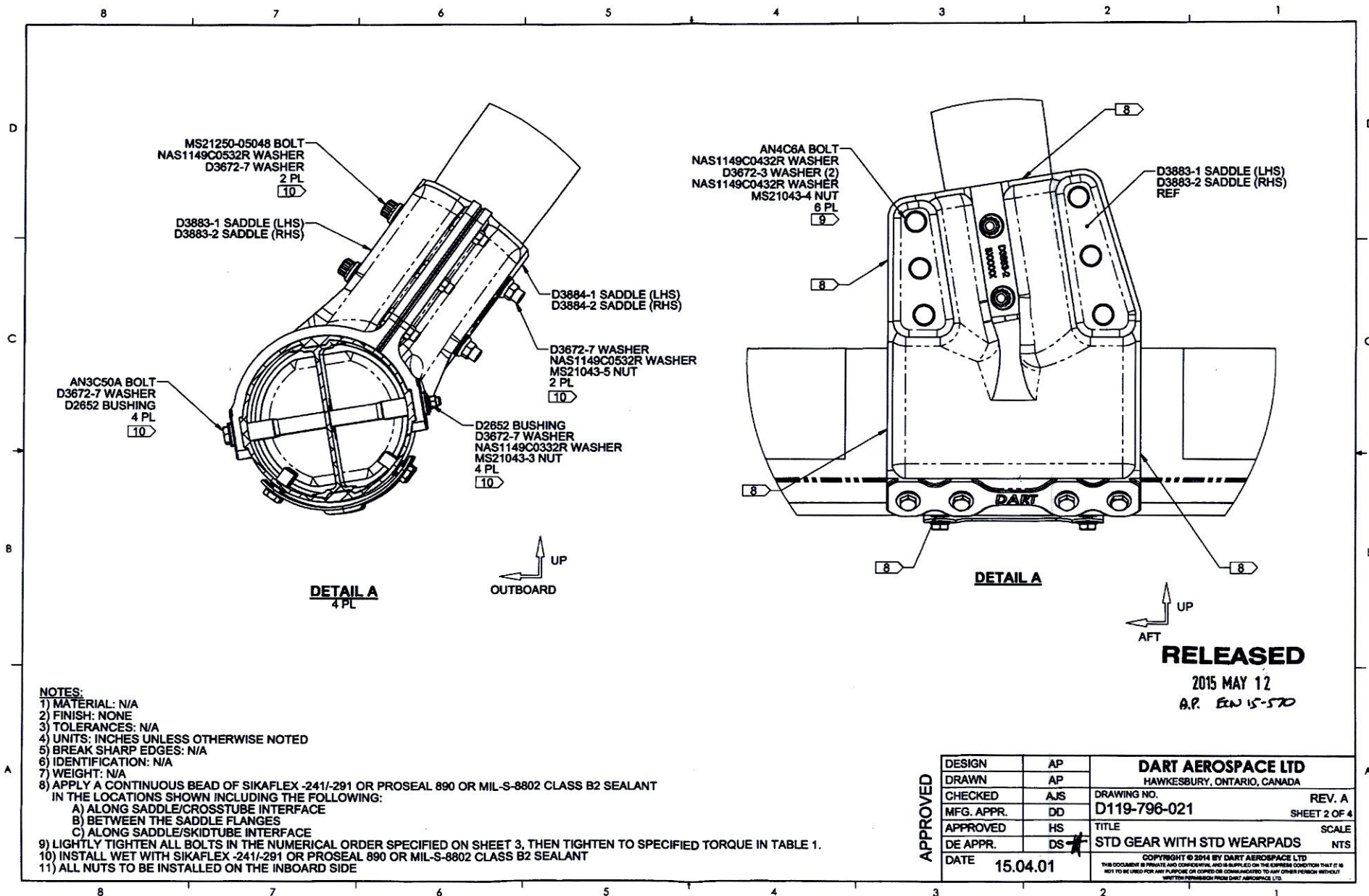
RELEASED
2015 MAY 12
A.R. ECHS-570

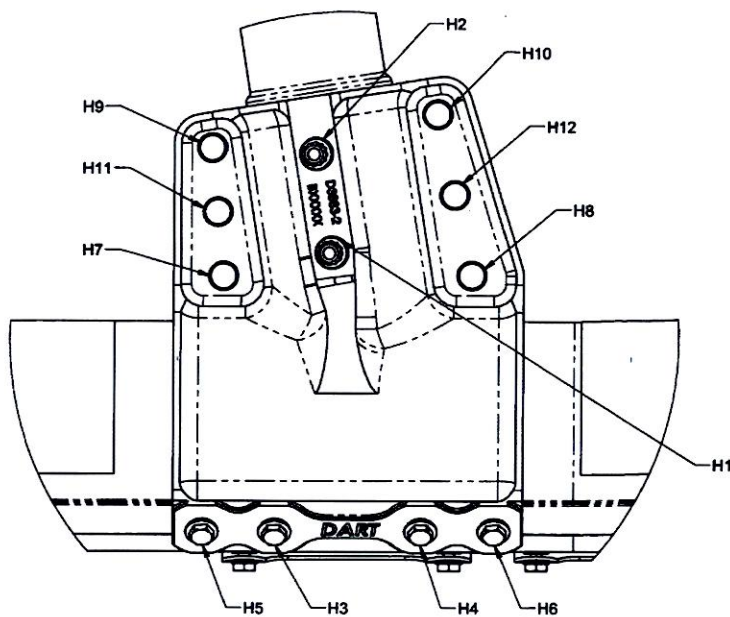
D119-796-021 STD GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

A NEW ISSUE		AP	15.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

2015 MAY 12

A.P. EW15-570

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO. D119-796-021	REV. A
	MFG. APPR.	DD		SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
	DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

